

Work Order ID 85211

June-04-12 1:47:32 PM

Plus
85211

Page 1

Item ID: D3207-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 6/04/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/05/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3207	C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D3702-1 as per Dwg								
<i>2024 .063</i>	Dwg Rev: <u><i>C</i></u>								
	Prog Rev: <u><i>C</i></u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-6-4

B12-6-4

85211

June-04-12 1:47:32 PM

N900040100

Stop *NS2*

6

6

Customer:

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

Quality Control

130

Brake NC

140

0.00

Quality Control

Work Order ID 85211

85211

Page 3

June-04-12 1:47:32 PM

Item ID: D3207-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 6/04/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/05/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 12:00 OVEN TEMPERATURE:
 FINISH TIME: 12:30

3200F

12:30

M121279

6x 11/06/06

6 12-6-6

6x 12/56/06

Work Order ID 85211

85211

Page 4

June-04-12 1:47:32 PM

Item ID: D3207-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 6/04/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/05/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

6x 12/06/06

6 54 12/06/06

12/6/7

MLJ 12/06/06

Picklist Print

June-04-12 1:47:32 PM

Page 1

Work Order ID: 85211

Parent Item: D3207-11

Parent Item Name: Bracket

Start Date: 6/04/12

Required Date: 6/05/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-03-23 JLM VERIFIED BY:EC
rev.c DD verf:EC IPP REV:B 12.05.10 per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	270.4700	0.161	1.0168421			

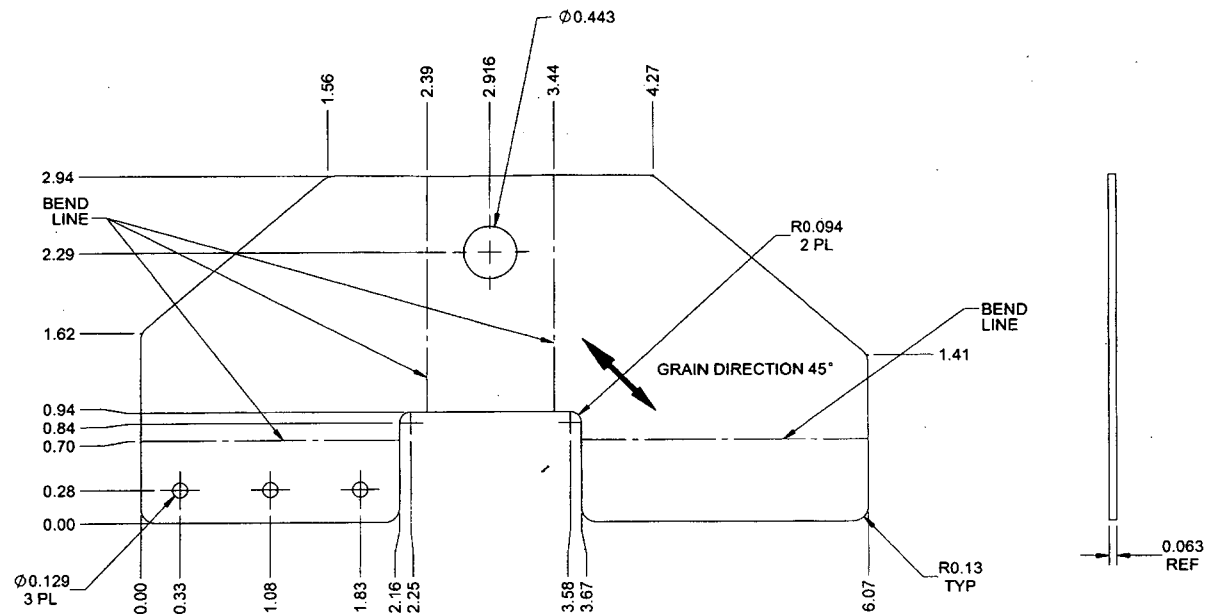
1812-6-4

Location	Loc Qty	Loc Code
MAT022	270.47	
119916	73.27	
121197	197.2	

121197

6

25



D3207-1F BRACKET FLAT PATTERN

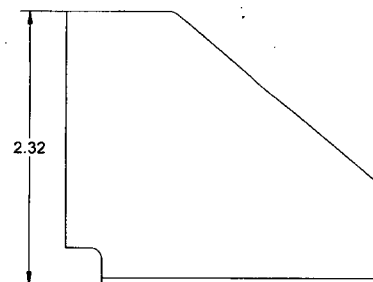
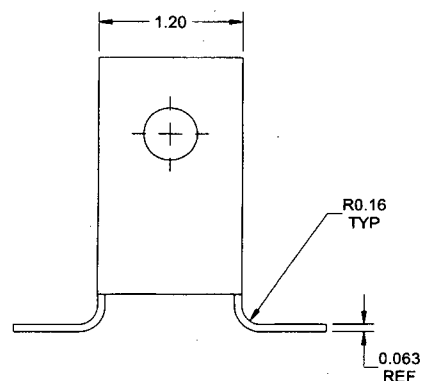
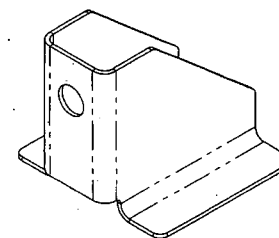
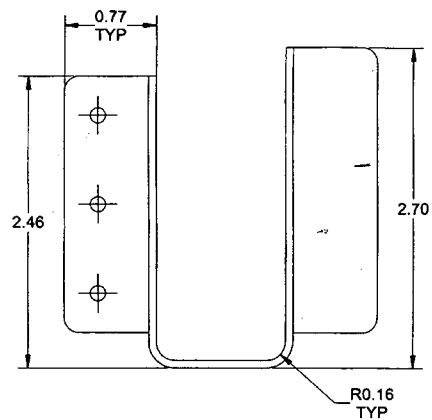
RELEASED
2012-05-09
MP

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

al08521

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3207	SHEET 2 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.05.04	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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D3207-11 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D3207-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

RELEASED
2012-05-09
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3207	SHEET 10 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries